

Date: Wednesday, 21/03/2007 1:21:29 PM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TUBE
Job Number	: 31403		
Estimate Number	: 12243		
P.O. Number	: N/A	Part Number	: D34773
This Issue	: 21/03/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3477 REV A
First Issue	: N/A	Project Number	: N/A
Previous Run	: 28751	Drawing Revision	: A
		Material	: N/A
Written By	: <u>[Signature]</u>	Due Date	: 28/03/2007
Checked & Approved By	: <u>[Signature]</u>	Qty:	4 Um: Each
Comment	: Est Rev:A New Issue 06-02-07 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S26GA	304/316 0.018 SHEET
Comment: Qty.: 0.1985 sf(s)/Unit Total: 0.7938 sf(s) 304/316 0.018 SHEET (M304S26GA) Batch: <u>M102393</u>		
2.0	SHEAR	SHEAR
Comment: SHEAR Cut as per Dwg D3477 (13.40" X 2.04")		
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Deburr 2-Roll as per Dwg D3477 3-Tack Weld as per Dwg D3477		
4.0	QC9	VISUAL WELDING INSPECTION
Comment: VISUAL WELDING INSPECTION		

MF 07-03-26

MF 07-03-26

MF 07-03-26

SB 07/03/26 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ _____ Date: 07/03/27

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:	Machine Or Operation:	Description :
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5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/03/26 (4)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 07/03/26 (4)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SB 07/03/27

Job Completion



U 07/03/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

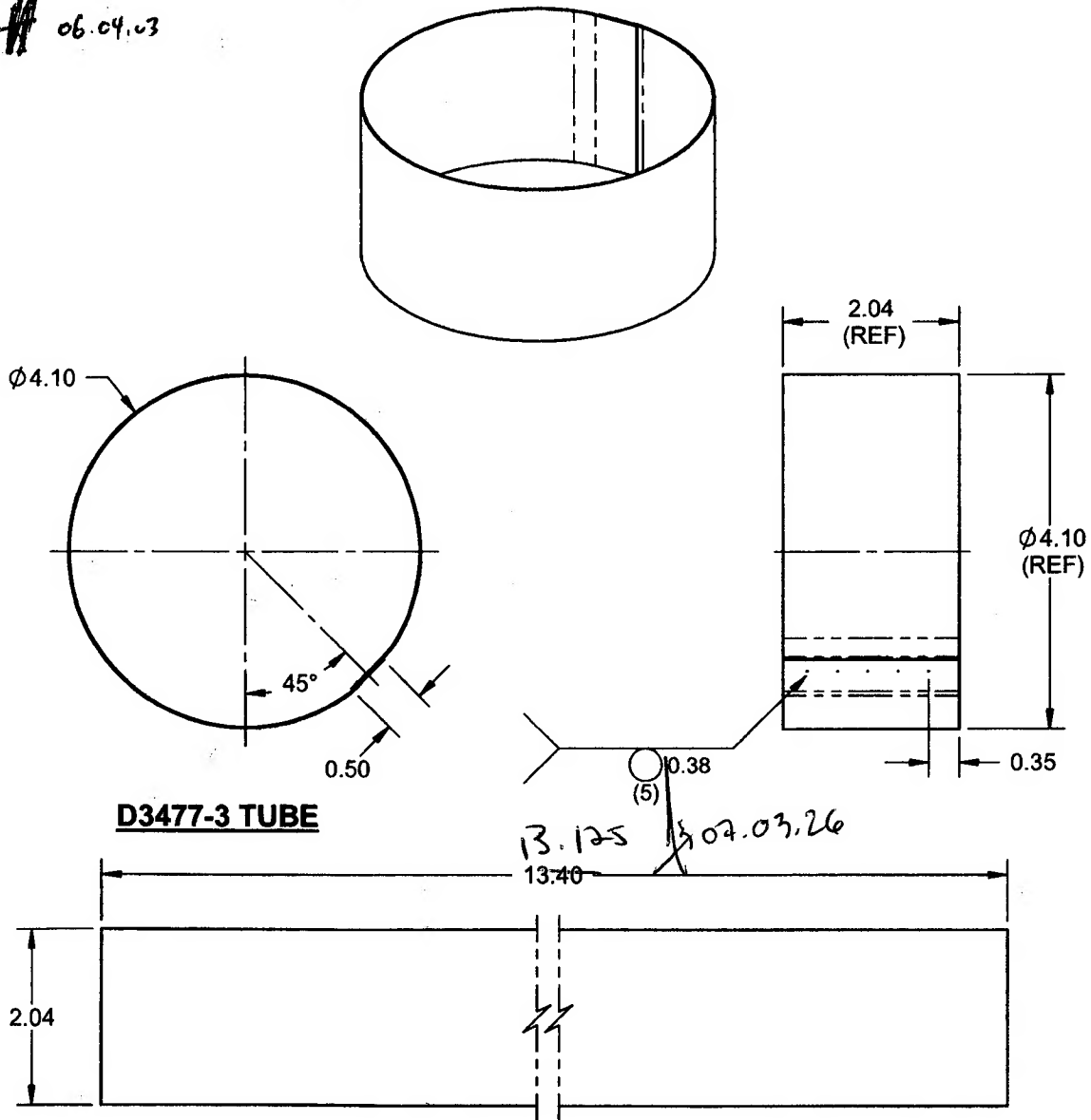
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3477	REV. A SHEET 3 OF 4
DATE 05.12.09		TITLE BLOWER INLET ADAPTER	SCALE 1:2

06.04.03**D3477-3 TUBE****D3477-3F TUBE FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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SPOT WELD TEST RECORD

AMS-W-6858A

CLASS 'C'

TEST NO: 3

EMPLOYEE: Melanie Fauteux

PART NUMBER: D 3477 - 3

JOB NUMBER: B 21403

MATERIAL TYPE: 304 / 316 SS

MATERIAL THICKNESS: .018

GROUP SPECIFICATION: SS

Group 1: Aluminum & magnesium

Group 2: Iron; nickel; cobalt

Group 3: Titanium

TEST RESULTS

PASS FAIL

VISUAL: [☒] [☐]

PENETRATION: [☒] [☐]

PULL STRENGTH: [☒] [☐] PSI Reading: _____

The individual named above has been trained and is qualified in accordance with standard AMS-W-6858A, and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 07/03/26

QUALIFIER: SB